

Work Order ID 131907

Tuesday, April 21, 2015 1:56:15 PM

131907

Page 1

RUSH

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw 19" X 24"
 Start Date: 4/20/15 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	H								
120	FLOW WATER JET	0.00							
120									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								
130	HAAS CNC VERTICAL MACHINING #1	0.00							
130									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140									
QC	Memo	0.00							
Quality Control									

(16)

15/04/23

DAS 14 15/04/29

(16)

15/04/30

PTO

DAS 14 9-89

16

15/04/30

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>131907</u> Part No. <u>D2432</u> NCR No. <u>15-4885</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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The pocket thickness .250' was .225-.240 R.C. Two way tape under the part. was ficker		Along outboard edges only, not high stress area. Acceptable.		Completed By DAS 14 15/04/30 9-89 Lead hand / Supervisor Approval Verification DAS 14 15/04/30 9-89 QC / QA Coordinator Approval 15-05-01 RD																																																																	
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Work Order ID 131907

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131907

Item ID: D2432

Accept

N900040100

Setup Start

***NS**

Revision ID:

Item Name: Bearpaw 19" X 24"

Stop

***NS**

Start Date: 4/20/15

Start Qty: 15.00

15

Cust Item ID:

Required Date: 4/20/15

Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

***NF**

QC:

Date:

SPC (Y/N):

Date:

Stop

***NF**

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

16

Ø

DAS

44

9-89

15/05/05

160

Identify as per dwg & Stock Location:

PKG

0.00

160

Packaging

Memo

0.00

Packaging

PPP 132184-8X
PPP 129996-4X
PPP 131929-4X

~~16~~ ~~15~~

SP 15-05-4

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

ML5 MAY 04 2015

ML5 MAY 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Picklist Print

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Page 1

Work Order ID: 131907

131907

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

701.8420

3.7

56

MUHMWB10

Revised 4/23

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT

608.475

m131661

208.475

m132063

400

MAT018

93.367

m131335

93.367

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function, ☐	Misread ☐																																																																		
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
OTHER :																																																																					

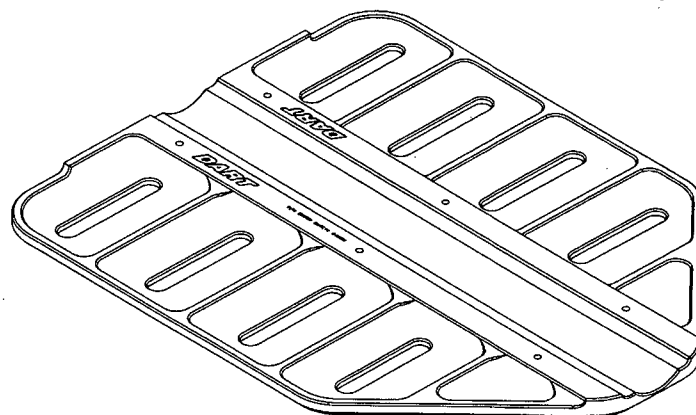
DART AEROSPACE LTD		Work Order: 131907
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

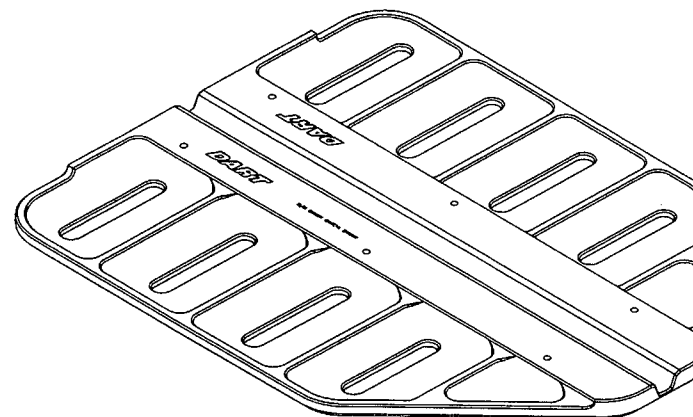
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.055X45°	✓		Vem	M206
B	0.200	+/-0.030	.200	✓		"	
C	0.25 x 45°	+/-0.030	.250X45°	✓		"	
D	R0.250	+/-0.030	R.250	✓		R-G	
E	0.250	+/-0.010	.245	✓		Vem	M1-06
F	0.625	+/-0.030	.615	✓		"	
G	0.375	+0.030/-0.010	.375	✓		"	
H	0.950	+/-0.030	.953	✓		"	
I	19.000	+/-0.030	19.000	✓		M-tape	M1-08
J	Ø0.260	+0.005/-0.000	Ø.260	✓		Vem	M1-06
K	Ø0.93	+/-0.030	Ø.930	✓		"	
L	0.30	+0.030/-0.000	.315	✓		"	
M	23.750	+/-0.030	23.750	✓		M-tape	M1-08
N	2.000	+/-0.030	2.000	✓		Vem	M1-06
O	0.38	+/-0.030	.380	✓		"	
P							
Q							
R							
S							
T							
U							
V							

Measured by: <i>AM</i>	Audited by: DAS 44 9-99	Preliminary Approval:
Date: 15/04/30	Date: 15/05/01	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	<i>AM</i>



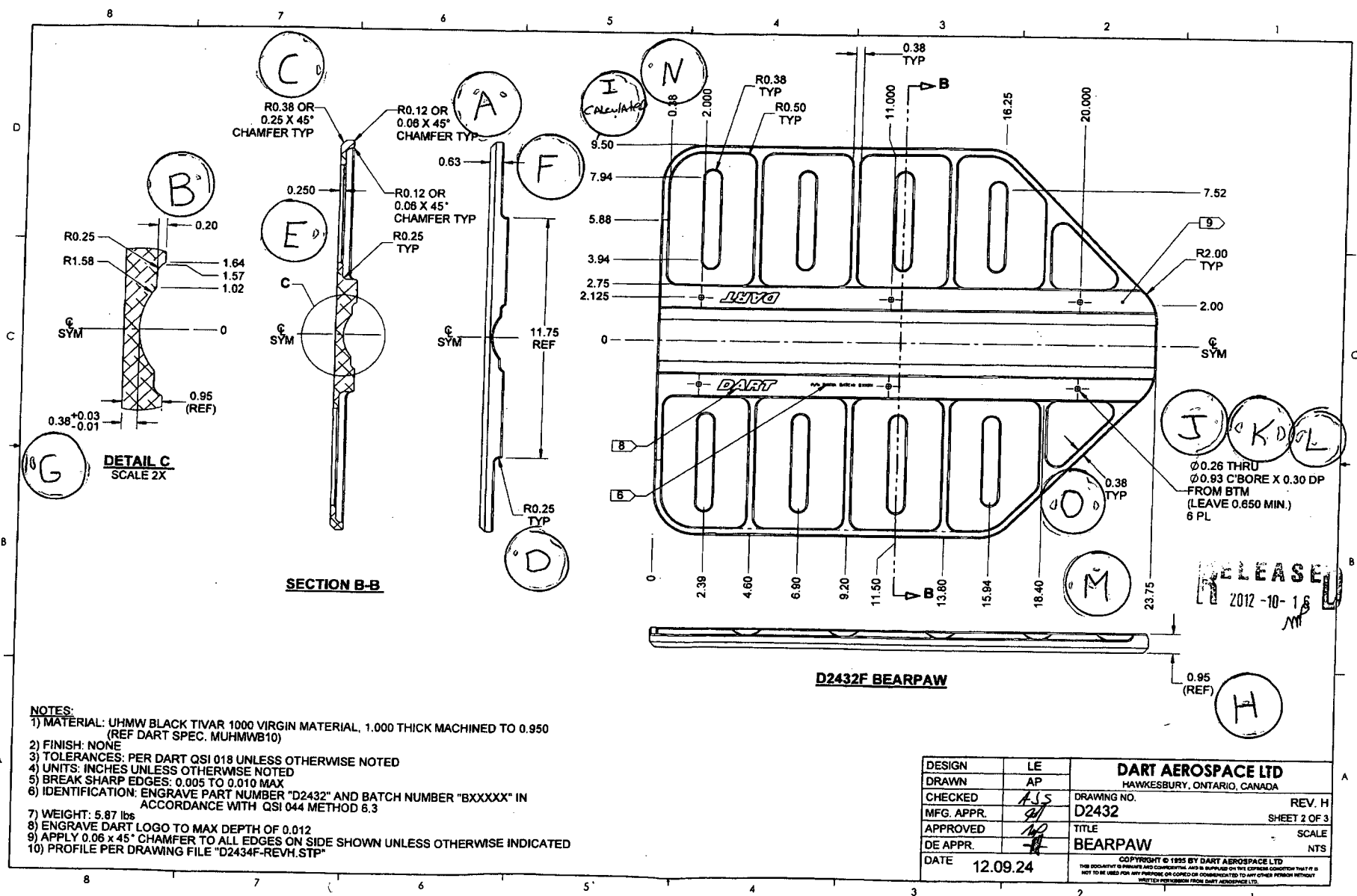
D2432F BEARPAW

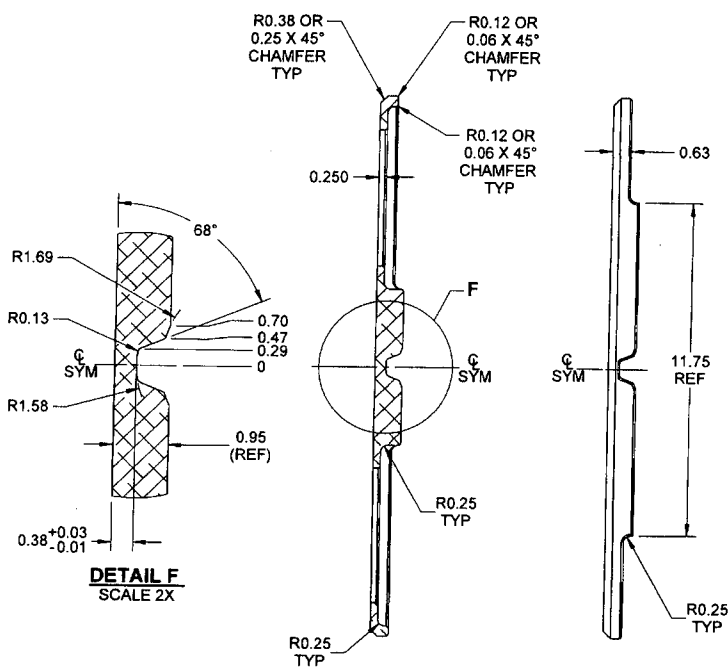


D2432-3 BEARPAW

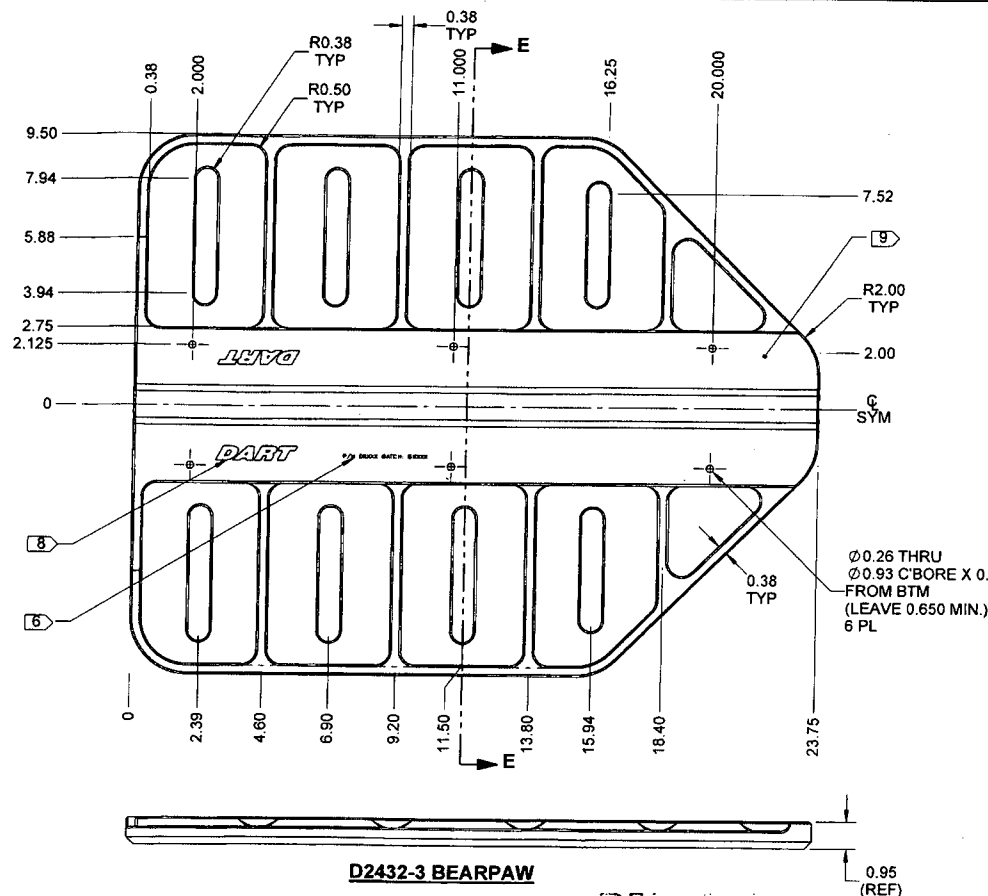
RELEASED
R 2012-10-16

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2432 TITLE BEARPAW SCALE NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AP		
CHECKED	ASS		
MFG. APPR.	2/1		
APPROVED	1/2		
DE APPR.	1/2	REV. H SHEET 1 OF 3	
DATE	12.09.24		





SECTION E-E



D2432-3 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 6.25 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2432-3-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. H
MFG. APPR.	AP	D2432	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BEARPAW	NTS
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